

Work Order ID 124828

September-24-14 9:18:44 AM

124828

Page 1

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Spacepod Door RH Stop ***NS2***
 Start Date: 9/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/10/14 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	Rev E

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>25906</u>								
	Description: D3186-2M Door								
	Supplier: Delastek								
	Conformity Certificate and Process sheet required								
	Ship 3 Items from Previous steps								

CL 14/09/24 ①

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

1x SP14-11-5

Work Order ID 124828

124828

Page 2

September-24-14 9:18:44 AM

Item ID: D3186-2M Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod Door RH
 Start Date: 9/24/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/10/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				14/11/15	SM		
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>CA</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

14/11/15 SM

14-11-06

14/11/16

ME 14-11-06

Picklist Print

September-24-14 9:18:44 AM

Page 1

Work Order ID: 124828

124828

Parent Item: D3186-2M

D3186-2M

Parent Item Name: Spacepod Door RH

Start Date: 9/24/14

Required Date: 10/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2P		Purchased	No			110	Each	0.0000	1	1			

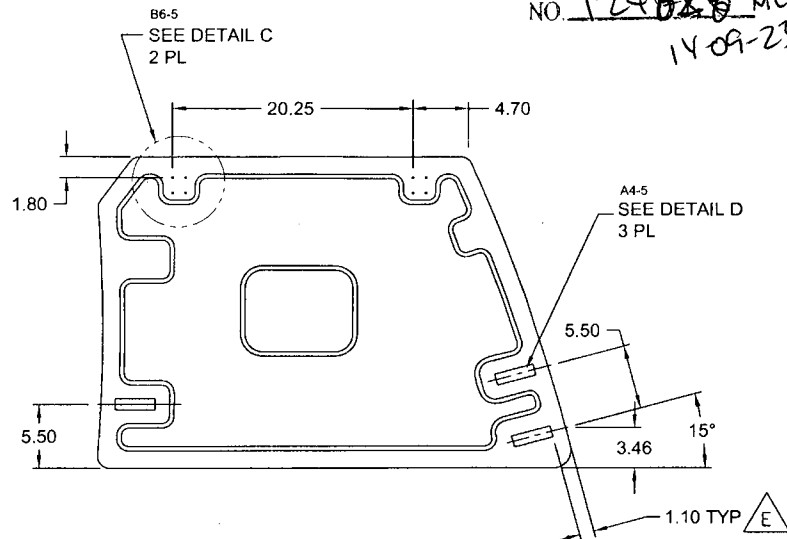
D3186-2P

Spacepod Door

1X 8P14-11-5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

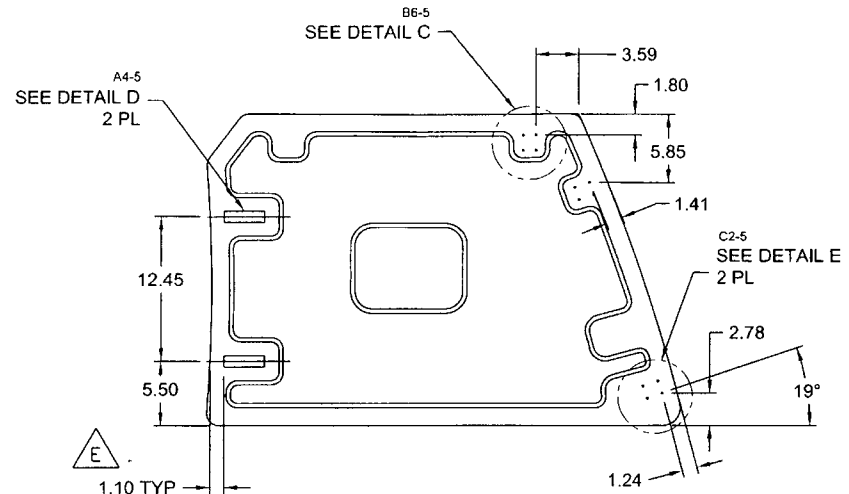
WITHOUT NOTICE
WORK ORDER
NO. 124828 MW
1409-23



D3186-1 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



D3186-3 SPACEPOD DOOR, LH
MAKE FROM D3186-1M

RELEASED
2009-09-09

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	AS	D3186	SHEET 1 OF 5
APPROVED	AW	TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

D

D

C

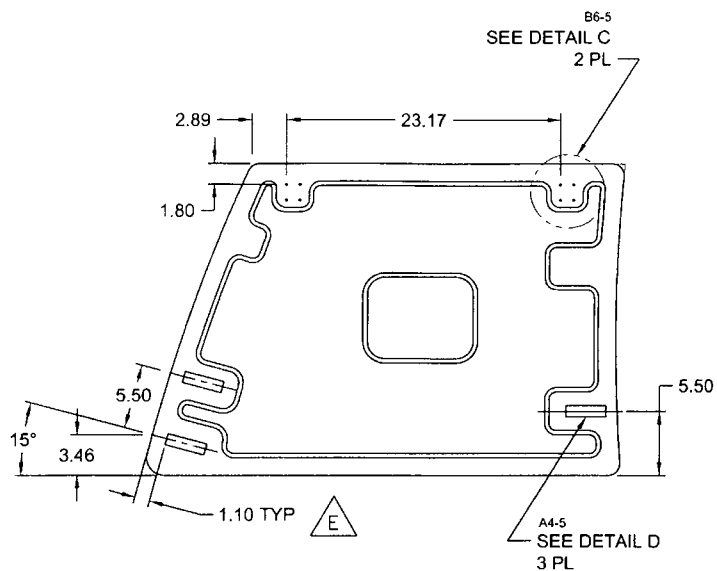
C

B

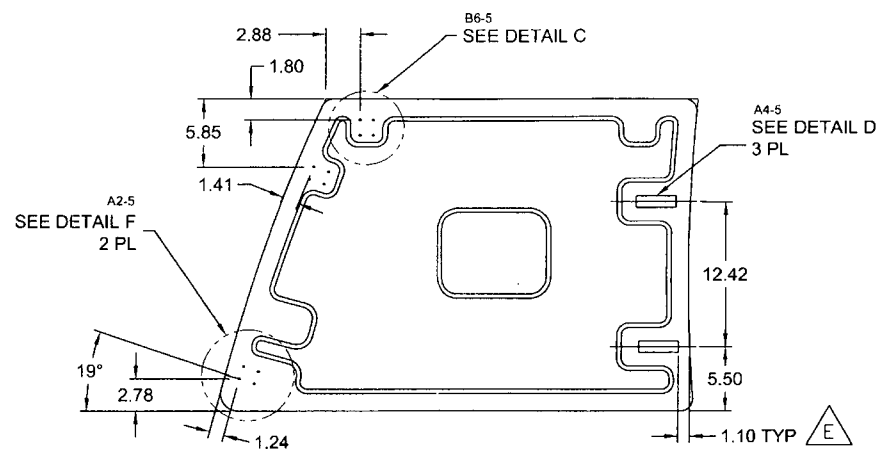
B

A

A



D3186-2 SPACEPOD DOOR, RH
MAKE FROM D3186-2M



D3186-4 SPACEPOD DOOR, RH
MAKE FROM D3186-2M

RELEASED
2008-09-09

NOTES:

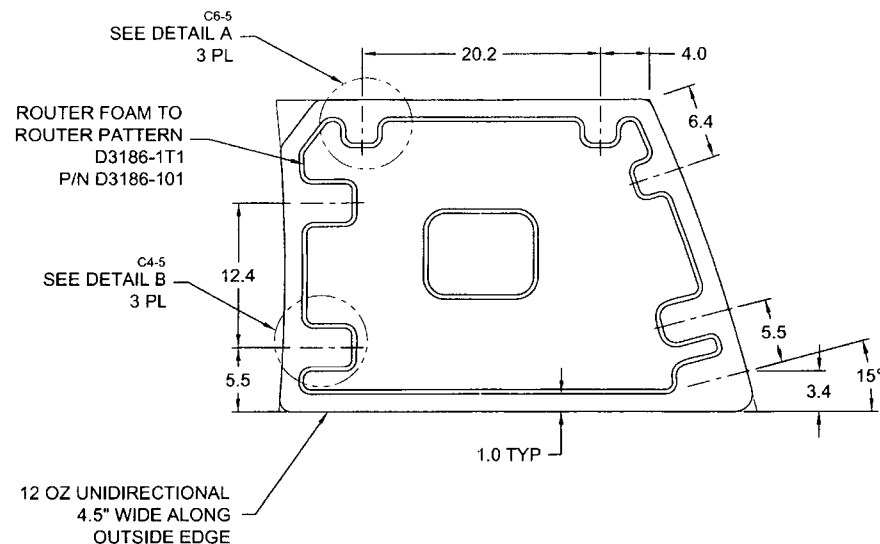
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

NOTES:

1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 LAMINATE PER DART QSI 006 4.0
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

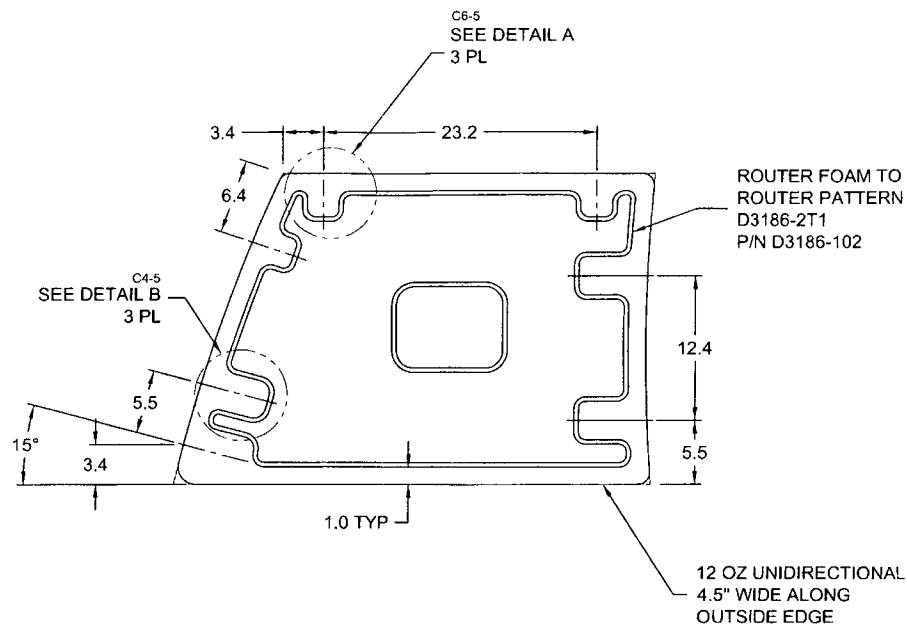
8) USE MOLD DT8005 FOR DOOR LAYUP

RELEASED
 2009-08-08

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	RP	D3186	SHEET 3 OF 5
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



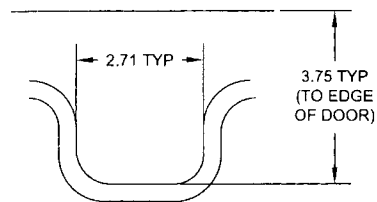
NOTES:
1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
LAMINATE PER DART QSI 006 4.0
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 7.0 lbs
8) USE MOLD DT8006 FOR DOOR LAYOUT

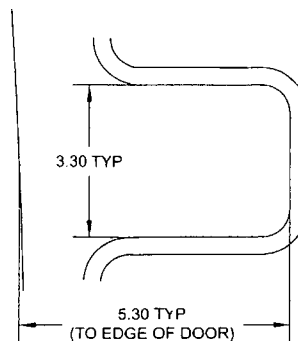
D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED
2009-09-09

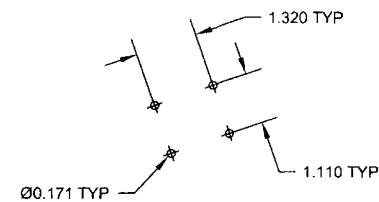
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. #
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE PURCHASER UNDER THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR RECOMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



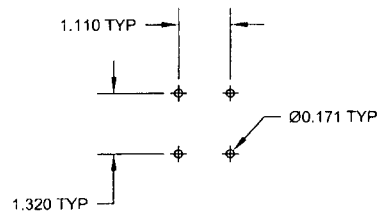
DETAIL A
SCALE 4X
D6-3
D4-4



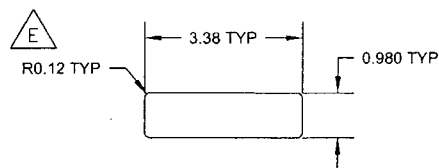
DETAIL B
SCALE 4X
C6-3
C6-4



DETAIL E
SCALE 4X
C1-1

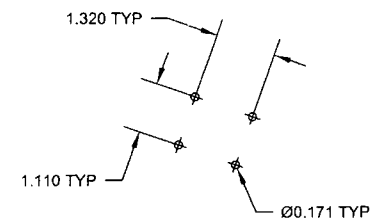


DETAIL C
SCALE 4X
D7-1
D3-1
D6-2
D3-2



NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR

DETAIL D
SCALE 4X
C5-1
D4-1
B6-2
C2-2



DETAIL F
SCALE 4X
C4-2

RELEASED
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25906**

Purchase Order Date 9/24/2014

PO Print Date 9/24/2014

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3186-2P MAKE AS PER DWG D3186 REV.E B124828	Spacepod Door	10/10/2014 Yes 10/10/2014 30		1.00 Each	\$726.64	\$726.64
						Line Total:	\$726.64
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart notification by supplier A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	10/10/2014 No 10/10/2014		1.00	\$0.00	\$0.00

SP14-11-5

Note:

9/24/2014



DELASTEK Inc.
2699 Se Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	58707
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Dale Bates

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
04-11-2014	24-09-2014	25024	Chantal Lavoie	PO25906	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect.	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship	Item number	Description	
1	0	✓	DKC134-0060	Line #1 N° D3186-2M Spacepod Door RH B124828 Dwg. D3186 Rév.: E DOCUMENT INCLUS Serial # B124828	U of M: Chaq Lot # 64577
8014-11-5					

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE	Nom Dessin	: SPACEPOD DOOR RH
Numéro Job	: 64577	Numéro Article	: DKC134-0060
Numéro	: 3769	Numéro Dessin	: -
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-09-25 No. :	Révision dessin	:
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: - - Type :	Date Due	: 2014-10-02
Job précédente	: 56880	Qté:	1 Ud UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de dessin: D3186-2M rev. E		



E.O.: N/A

Feuille de Procédé Rév.: 03 AMB0349 remplacé par
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

B124828
COPIE



Produit additionnel








Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
Comment Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) N° 83634, Frekote Loctite Wolo N° de Lot: 4802810AA		
2.0	PRÉPARATION	Préparation du moule
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire la préparation du moule N° DT 8006 selon IG 0009. Date: 30/09/14 Sceau:		
3.0	AAC1885	Tissu à délaminer Release ply B
Comment Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B # de Lot: N/A		
4.0	AAC1887	Wrightlon 5200 Bleu P3
Comment Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: N/A		
5.0	AC0885	Feutre de drainage N° Airweave N 10
Comment Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)		













Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	64577	Numéro	DKC134-0060
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)		
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment	Qty.: 4.50 VERGE(s)/Unit Total : 4.50 VERGE(s)	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-49418-1	
8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)		
9.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Comment	Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)	N° TG-13-U, Fiberglass 13 oz N° de Lot: 1-36302-1	
10.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
Tailler le matériel selon les différents patrons de découpe.			
Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.			
Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.			
Date:	30/09/14	Scellé:	
11.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)	Catalyst N° DDM-9 N° de Lot: 1-27829-1	
12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)	Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4798810AB	
13.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs		
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.			
Date:	30/09/14	Scellé:	










Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	64577	Numéro	DKC134-0060
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
14.0	LAMINAGE	Faire le laminage	
			
Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.			
Date: <u>30/09/14</u> Sceau:  			
15.0	BAGGING	Faire le bagging sur la pièce	
			
Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012.			
Laisser sécher pendant 4 heures minimum.			
Heure début Curing: <u>1:45</u> Heure Fin Curing: <u>8:00</u>			
Date: <u>30/09/14</u> Sceau:  			
16.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)			
Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>			
17.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)			
Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>4798810AB</u>			
18.0	PREP-GENERAL	Préparation du matériel	
			
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.			
Date: <u>30.09.14</u> Sceau: 			
19.0	DKC134-0057	Foam Core N° D3186-102 (Porte D3186-2)	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)			
Foam Core N° D3186-102 (Porte D3186-2) N° de Job: <u>64578</u>			

Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	64577	Numéro	DKC134-0060
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AAC1611	Polybond B46F	
Comment	Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s) Polybond B46F N° de Lot: <u>1-40597-1</u>		
21.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs		
Retirez le bagging.			
Pour aider au positionnement de 13 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.			
Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)			
Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.			
Date:	<u>1/10/14</u>	Sceau:	 
22.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs		
Faire la poche à vide selon IG 0012.			
Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.			
Heure début Curing:	<u>8:45</u>	Heure Fin Curing:	<u>10:15</u>
Date:	<u>1/10/14</u>	sceau:	 
23.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0400 GALLON(s)/Unit Total: 0.0400 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
24.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min N° de Lot: <u>4798810AB</u>		

Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 64577

Nom Dessin: SPACEPOD DOOR RH
Numéro DKC134-0060

Numéro Job:



Séq.:

Machine ou Opération:

Description :

25.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date:

2/10/14

Sceau:



26.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 13 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date:

2/10/14

Sceau:



27.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing:

8:30

Heure Fin Curing:

8:00

Date:

2/10/14

sceau:



28.0

DÉMOULAGE

Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date:







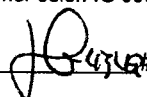



03-10-14

Sceau:












Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD DOOR RH
Numéro Job:	64577	Numéro	DKC134-0060
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
29.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
	Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.		
Date:	6/10/14	Sceau:	
30.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-54556-3		
31.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 476841044		
32.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
	Appliquer une couche de primer selon IG 0008.		
Date:	06-10-14	Sceau:	 # de fiche de mélange: 10524
33.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler N° de Lot: N/A		
34.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.		
	Faire un léger sablage (Grit 220) de toutes les surfaces.		
Date:	02-10-14	sceau:	
35.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s) Dupont Primer N° 7704S N° de Lot: 1-54556-3		

Date: Jeudi, 2014-09-25 12:13:19
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: SPACEPOD DOOR RH	
Numéro Job: 64577	Numéro: DKC134-0060	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
36.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
Comment Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 4768410AA		
37.0	PRIMER	Application primer
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Appliquer une couche de primer selon IG 0008. Date: 07/10/14 Sceau:  # de Fiche de mélange: 10526		
38.0	INSPEC FINAL	Inspection finale
 		
Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs Faire l'inspection finale par la qualité selon le dessin. Date: 09/10/14 Sceau: 		
39.0	EMBAL / ENTREPO	Emballage & Entreposage
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Emballer et entreposer selon IG 0057. Date: 14-10-14 Sceau: 4436 N.M		

Location/Lot Activity

Page 1 of 1

Thursday, November 06, 2014 12:40:13 PM

Criteria : All Items All Locations Lot: 124828 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D3186-2P / Spacepod Door	Main Warehouse CA	124828	DCUSER		1.0000		1.0000		
					11/5/2014	-1.0000	124828	-1.0000		(\$726.64)
								-1.0000		(\$726.64)
PO Receipt	D3186-2P / Spacepod Door	Main Warehouse CA	PO25906	DCUSER		0.0000		0.0000		
					11/5/2014	1.0000	124828	1.0000		\$726.64
								1.0000		\$726.64